

Date: Friday, 1/5/2007 10:35:51 AM
 User: Jean-Luc Menard

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: UNION
Job Number	: 30185		
Estimate Number	: 12630		
P.O. Number	: <i>N/A</i>	Part Number	: D2127251093
This Issue	: 1/5/2007 S.O. No. : <i>N/A</i>	Drawing Number	: D212-725-1 REV A
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: <i>N/A</i>	Drawing Revision	: A
Previous Run	: <i>N/A</i>	Material	: <i>N/A</i>
Written By	: <i>[Signature]</i> 07-01-05	Due Date	: 1/12/2007
Checked & Approved By	: <i>[Signature]</i>	Qty:	7 Um: Each
Comment	: Est Rev:A New Issue 07-01-05 JLM		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
---------	-----------------------	---------------

1.0	M303H1000	Inventory
-----	-----------	-----------



Comment: Qty.: 0.2625 f(s)/Unit Total : 1.3125 f(s)
 303 1.00" HEX BAR
 Batch: *M18453* *1.75 FT.*

7.

2.0	HARDINGE	HARDINGE CNC LATHE SMALL
-----	----------	--------------------------



Comment: 1-TURN AS PER FOLIO Fa662 & DWG D212-725-1,
 FOLIO REV: *A*
 DWG REV: *A*

2-DEBURR AS REQUIRED

[Signature] 07-01-09

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
-----	-----	--



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

[Signature] 07-01-09

4.0	QC8	SECOND CHECK
-----	-----	--------------



Comment: SECOND CHECK

[Signature] 07-01-09

5.0	PACKAGING 1	PACKAGING RESOURCE #1
-----	-------------	-----------------------



Comment: PACKAGING RESOURCE #1
 Identify and Stock
 Location: *6*

07-01-09

Date: Friday, 1/5/2007 10:35:51 AM
User: Jean-Luc Menard

Process Sheet

✓ Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: UNION

Job Number: 30185

Part Number: D2127251093

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC21

FINAL INSPECTION/W/O RELEASE



⑦

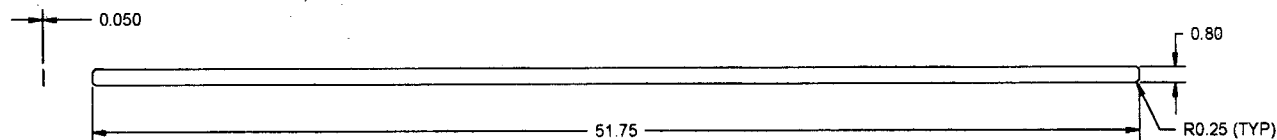
Comment: FINAL INSPECTION/W/O RELEASE

D 07/01/09

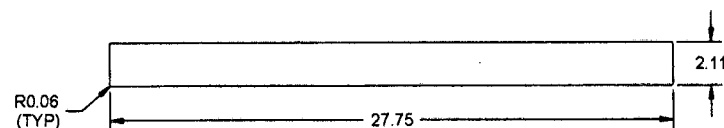
Job Completion



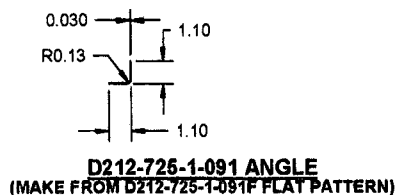
LL 07/01/09



D212-725-1-089 STRAP

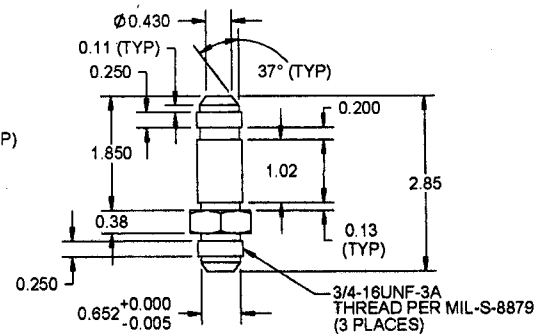


D212-725-1-091F FLAT PATTERN



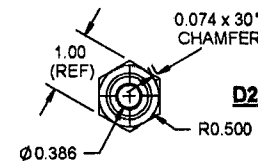
D212-725-1-091 ANGLE

(MAKE FROM D212-725-1-091F FLAT PATTERN)



D212-725-1-093 UNION

(SCALE 1:3)



D212-725-1-105 BUSHING

(SCALE 1:3)

D212-725-1-089 NOTES:

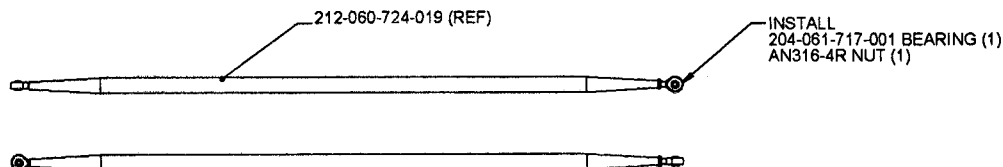
1) MATERIAL: AISI 304/316 STAINLESS STEEL 0.050 (18 GAUGE) SHEET, PER MIL-S-5019 (REF. DART SPEC. M304S18GA)

D212-725-1-091 NOTES:

2) MATERIAL: AISI 304/316 STAINLESS STEEL 0.030 (22 GAUGE) SHEET, PER MIL-S-5019 (REF. DART SPEC. M304S22GA)

GENERAL NOTES:

- 3) FINISH: NONE
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 7) IDENTIFY WITH DART P/N USING FINE POINT PERMANENT INK MARKER

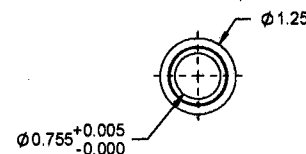


D212-725-1-921 ROD ASSEMBLY

(MADE FROM 212-060-724-019)

D212-725-1-921 NOTES:

- 1) MATERIAL: MADE FROM 212-060-724-019 TUBE ASSEMBLY
- 2) FINISH: NONE
- 3) IDENTIFY WITH DART P/N USING FINE POINT PERMANENT INK MARKER



D212-725-1-106 BUSHING

(SCALE 1:3)

D212-725-1-105 BUSHING:

1) MATERIAL: AISI 303/304/316 STAINLESS STEEL ROUND BAR (REF. DART SPEC. M303R)

D212-725-1-093 UNION:

2) MATERIAL: AISI 303 STAINLESS STEEL HEX BAR (REF. DART SPEC. M303H)

GENERAL NOTES:

- 3) FINISH: NONE
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 7) IDENTIFY WITH DART P/N USING FINE POINT PERMANENT INK MARKER

DESIGN DC	DRAWN BY RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED DS	APPROVED	DRAWING NO. D212-725-1	REV. A
DATE 06.12.08	TITLE 212S DETAIL PARTS	SHEET 33 OF 37 SCALE 1:8	

COPYRIGHT © 2006 BY DART AEROSPACE LTD.
THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.

12630

